Work Order ID 120637

Monday, June 09, 2014 10:12:24 AM

120637

Jup guin

Page 1

Start Date: Required Date:	D3574-6 Cabin Floor Protector 6/9/2014	*9* *9*	Accept	*N900 Cust Item 1 Customer:		100)* s	Setup Sta	! //	S1* S2*	
Reference: Approvals:	Process Plan:QC:	Date: 14-6-9 Date:	Tooling: SPC (Y/N):	· · · · · · · · · · · · · · · · · · ·	ate:	_ 	R	tun Sta Sto	~! <i>\</i> J	R1*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr		•						-		_
D3574	Rev B										
*1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	FLOW WATER JET		0.00				_2_	0		DAS 23 9-89	- 4-06-8
Waterjet FLOW CNC Waterje	Memo et 1-Cut as p Dwg Rev:	er Dwg D3574	0.00								
	Prog Rev:	<u> 13</u>									
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							DAS 23	1.1
110 QC Quality Control	Мето		0.00				<u></u>		<u></u>	9-89	14-06-2

DQA:		- Date:	•		WORK ORDER NON-	-C(ONFO	RMANCE / UPI	こうもろう DATE				DART	_
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Work Ordei	·				Rework	ı		Skid-tube	Crosstube	7		Water Jet	Engineering	
Part No	0				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality	
raitiv	·				Use-as-is			noforming	Finishing	\dashv R		re/Packaging	Other	
NCR No	0.				Suspected Unapproved		1110111	· · · · ·	Composite	┤ ¨	00,000	Supplier	→ →	
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion		ate	Verification	QC Inspector	
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Landin	_			· -	General	_	1 ,_		Г	- 1_			¬_	
S	Bending			<u> </u>	Bend	_	4	rogram	Ŀ	_		ensions	Pressure/Forced	
-	Centre No	ot Concei	ntric	-	BOM/Route		Grain		ļ-		•	tolerance	Set-up	
-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		L	→	Incorre	 	Temperature/Cure	
-	Crimp/Kir	nk/Ripple	:/Wave	_	Burrs	-	4 .	ion Incomplete/Unqu		_	Lost/Mi	ssing	Weld	
-	Cuffs			<u> </u>	Countarion	\vdash	4	ions Incomplete/Und	ciear	-	Moved	L Vrans	Wrong Stock Pulled	
-	Crushing	.+		_	Countersink	-	-	gned/off center	-		ioned V er Loss/		Other	
-	Heat Treat Inspection Strip in Tube			<u> </u>	Cut Too Short	-	Mislabe		Ĺ	_l POW	ei LOSS/	ourge [Jouner	\dashv
}	Marks/Ch	•	eaur	-	Drawing Drill Holes	\vdash	Misread Off-set							-
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}	Turning Sequence Wave/Twist in Tube				Fit/Function	-	4	Sequence					<u> </u>	\dashv
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Work Orde Monday, June 0				*120	637*						Page 2
Item ID: Revision ID: Item Name: Start Date:	D3574-6 Cabin Floor F 6/9/2014	Protector Start Qty: 2.00	*2*	Accept	*N900		100)*	Setup Sta		S1* S2*
Required Date:		Req'd Qty: 2.00	*2*		Customer:	D.				,	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:]	Run Sta Sto	' ^ \	R1* R2*
Sequence ID/ Work Center II 120 *1 20* QC Quality Control)	Operation Description QC8- Inspect parts - secondary Memo	and check	Set Up/ Run Hours 0.00	Tool ID DAS 27 9-89	Tool#	Plan Code	Accept Qty (2) covn +	Reject Qty	Reject Number	Insp. Stamp
130 *120* Small Fab Small Fab		Small Fab Memo Deburr if ne	cessary.	0.00	Eng 27 6-)						

0.00

0.00

QC5- Inspect part completeness to step on W/O

Memo

140

140

Quality Control

DQA:		Date:						_				TOART
246		Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	1
Work Ordei	r:				DISPOSITION			A	AGAINST DE	PARTMENT	/PROCESS	
				_	Rework			Skid-tube C	rosstube	7	Water Jet	Engineering
Part No	0.				Scrap			}	mall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			Ŭ	Finishing	-	re/Packaging	Other
NCR No	0				Suspected Unapproved			· —	mposite	1	Supplier	
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Root				Desci	ription of work order update	Į, I	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	on	Date	Verification	QC Inspector
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Doc/Data												
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landling/Pre												
Material									•			
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Offset/Setup												
rocess												
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Training												:
Transport	:					l						
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						FAI	ULT CA	regory				
Landing	g Gear				General		-			-		_
	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
_	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ાં	Temperature/Cure
	Crimp/Kir	Crimp/Kink/Ripple/Wave			Burrs		Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing	Weld
	Cuffs			Contamination		Instruct	ions Incomplete/Uncle	ar	Part Moved		Wrong Stock Pulled	
	Crushing			Countersink		Misalig	ned/off center		Positioned V	Vrong	_	
	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread	t				
	Marks/Ch	atter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of	Calibration				
	Wave/Tw	ist in Tul	oe .		Fit/Function		Out of	Sequence				

Work Orde Monday, June 0				*120)637*						Page :
Item ID: Revision ID:	D3574-6			Accept	*N900	040	100)* s	etup Star	t *N	S1*
Item Name:	Cabin Floor I	Protector							Stop	, * N	S2*
Start Date: Required Date:	6/9/2014 6/11/2014	Start Qty: 2.00 Req'd Qty: 2.00	*9* *9*		Cust Item I Customer:	D:					,
Reference:											
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		R	kun Star	\ \J\	R1*
- 	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	, *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		Identify as per dwg & Sto		0.00				$2 \times$	DAS	i Hini	0.0.2047
Packaging Packaging		Мето	PPP 1206	od 7 0.00					28 9-89		0 9 2014

160

1 FN Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

MLJ 1406-10 AD14-6-9

DQA:		- Date:			WORK ORDER NON	~	0NE01	DAGABLEE / LIDDA	TE			DART
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Work Orde	:r:				Rework	1		Skid-tube Cro	osstube	7	Water Jet	Engineering
Part N	lo.				Scrap			—	mall Fab	Pro	d. Eng. Coor.	Quality
	-				Use-as-is			~ <u>—</u>	inishing	-1	re/Packaging	Other
NCR N	lo				Suspected Unapproved			· -	mposite]	Supplier	
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Offset/Setup												
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						FAI	ULT CAT	TEGORY				
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Į	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
Ĺ	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	:i	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualit	fied	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclea	ar	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong	_
[Heat Trea	at			Cut Too Short		Mislabe	led		Power Loss/S	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread	d			<u>-</u>	
[Marks/Ch	natter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of 0	Calibration				
[Wave/Twist in Tube				Fit/Function		Out of 9	Sequence				

Picklist Print

Monday, June 09, 2014 10:12:23 AM

Work Order ID: 120637

120637

Parent Item:

D3574-6

D3574-6

Parent Item Name: Cabin Floor Protector

Start Date: 6/9/2014

Required Date: 6/11/2014

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07.07.23 EC verified by: JLM

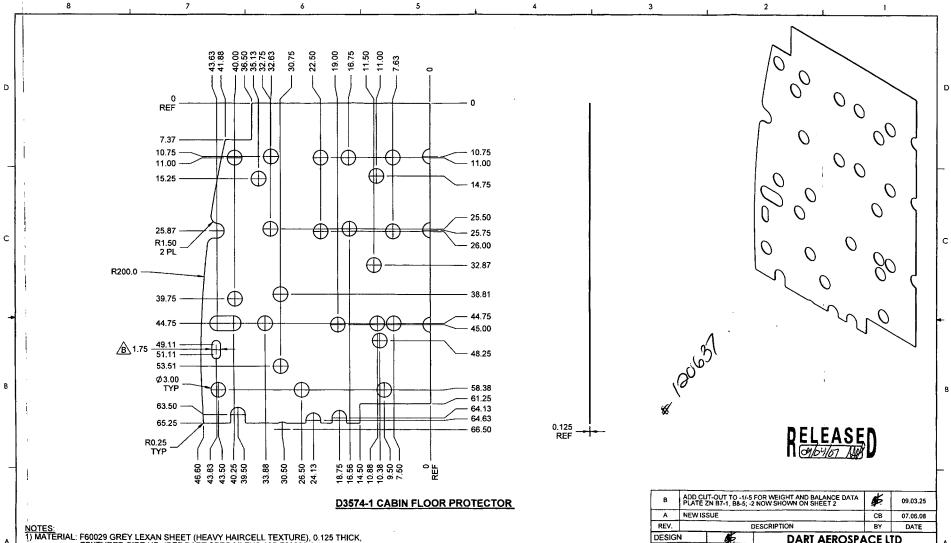
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MLEXS.125-F60029-04		Purchased	No				sf	3,526.525		5/2			DAS 23	
*MI FXS 1	25-F60	<u> </u>	*						**	64			23 9-89	IU.

GE PLASTICS LEXAN SHEET

Location	Loc Oty	Loc Code	
MAT019	3526.525		****
124866	106		
m126425	160.925		<u> </u>
m127934	699.6		
m128746	2560		128746

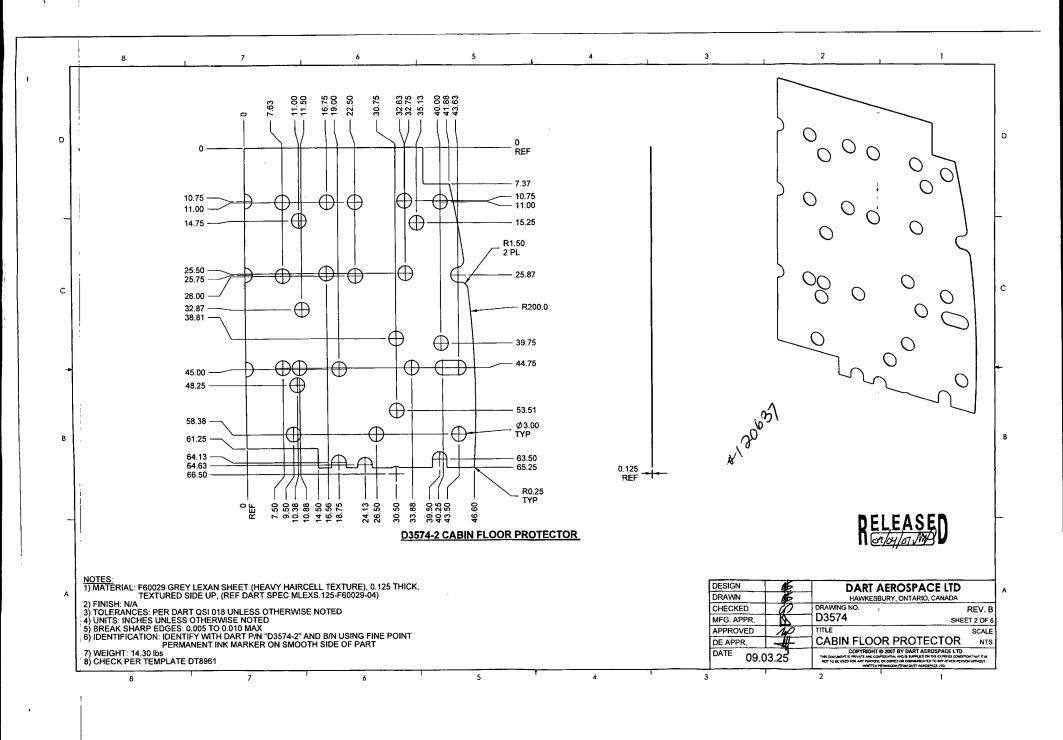
Page 1

DQA:			Date:												DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFO	RMANCE / UP		Wo	ork Order up	odate only		AEROSPACE
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Part N	In					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	\dashv	Quality
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	\dashv	Cracks				Broken/Damage/Defect		Hardwa			-	Part Incorred		\dashv	Temperature/Cure
		Crimp/Kink/Ripple/Wave			_	Burrs	L.	1 '	ion Incomplete/Unq	` .	_	Part Lost/Mi	ssing		Weld
	—	Cuffs				Contamination		4	tions Incomplete/Un	nclear	\dashv	Part Moved			Wrong Stock Pulled
	-	Crushing			Countersink		1 7	gned/off center].	-	Positioned V	_			
		Heat Treat				Cut Too Short	_	Mislabe		Į.		Power Loss/	Surge		Other
	_	Inspection Strip in Tube				Drawing		Misread							
	Marks/Chatter					Drill Holes		Off-set							
	-	Turning Sequence				Finish		4	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function	L	Out of S	Sequence						

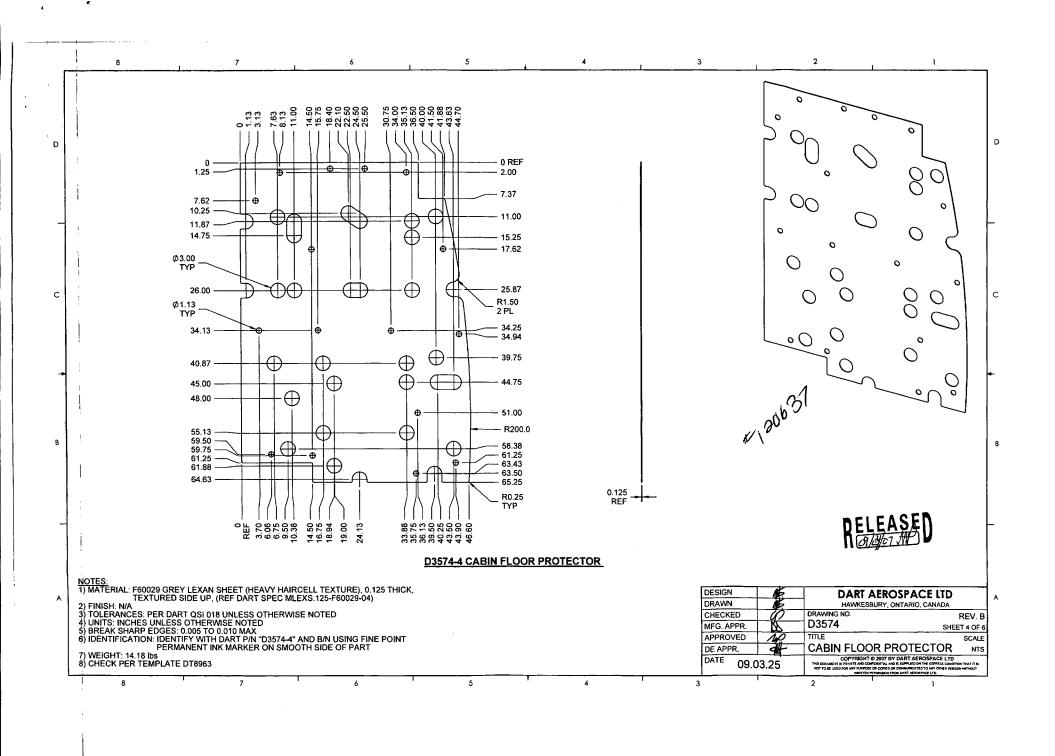


	A	NEWIS	SUE			CB	07.06.08
NOTES:	REV.				DESCRIPTION	BY	DATE
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,	DESIG	N	4	6	DART AEROSP	ACE L	TD
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)	DRAW	N		ķ	HAWKESBURY, ONTAR		
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	CHECK	KED	Ù	9	DRAWING NO.		REV. B
4) UNITS: INCHES UNLESS OTHERWISE NOTED	MFG. A	APPR.	Ŋ	<u></u>	D3574		SHEET 1 OF 6
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT	APPRO	OVED	14	Ø.	TITLE		SCALE
PERMANENT INK MARKER ON SMOOTH SIDE OF PART	DE API	PR.	4	#	TCABIN FLOOR PROT	TECTO	DR NTS
7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961	DATE	09.0	3.25)	COPYRIGHT @ 2007 BY DART. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED FOR ANY PURPOSE CALCIDADED OR COMMENT WRITTEN PERMISSION FROM DART A	CATED TO ANY OTH	S CONDITION THAT IT IS

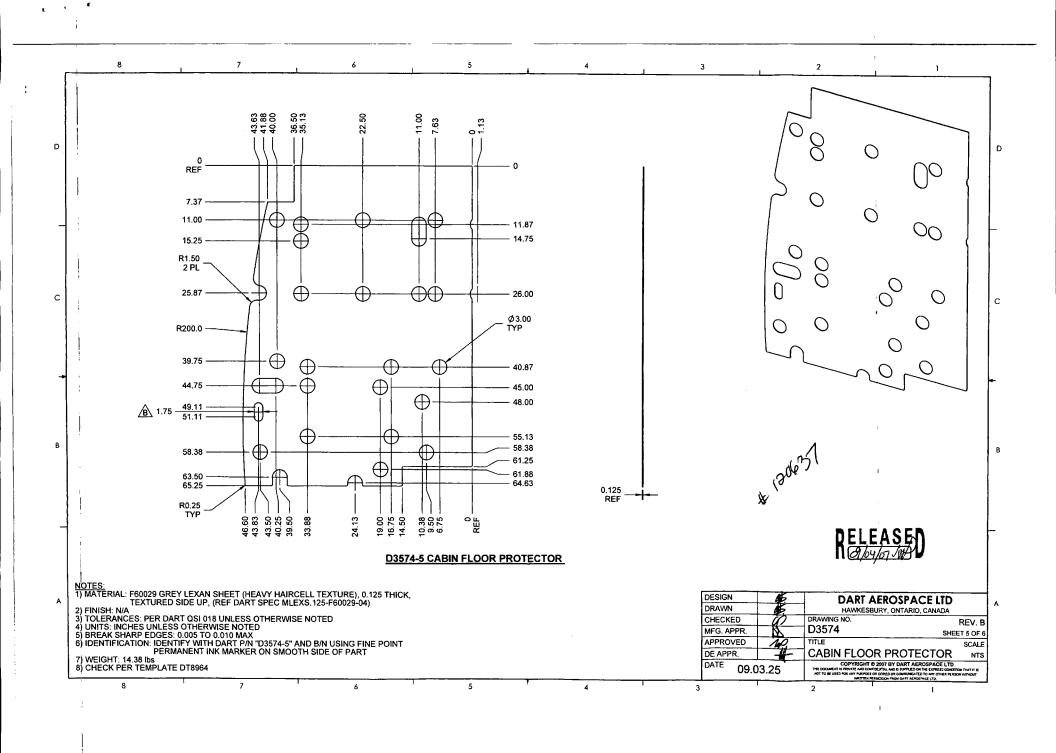
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QA Closed:		Date:			WORK ORDER NON-	-C(JNFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Marile Onda					DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS	
Work Orde	·r:				Downer! -			Skid-tube Crosst	.ha	1	Water Jet	7 [
Part N	0				Rework Scrap			Skid-tube Crosst Machining Small	_	Pro	d. Eng. Coor.	Engineering Quality
raitiv	·			_	Use-as-is			noforming Finish			e/Packaging	Other
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Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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Landin	g Gear				General		1		_	7		- .
-	Bending			<u> </u>	Bend		1	rogram	<u> </u>	Outside Dim		Pressure/Forced
_	Centre No	ot Concei	ntric	<u> </u>	BOM/Route	_	Grain			Over/Under		Set-up
-	Cracks				Broken/Damage/Defect		Hardwa		_	Part Incorred	<u> </u>	Temperature/Cure
-	Crimp/Kir	nk/Ripple	:/Wave		Burrs	<u> </u>	4	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs			<u> </u>	Contamination	<u> </u>	4	ions Incomplete/Unclear	-	Part Moved	<u> </u>	Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	<u> </u>	4	ned/off center	-	Positioned W	_	7
<u> </u>	Heat Treat Inspection Strip in Tube			<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
}		•	Tube		Drawing	_	Misread					
	Marks/Ch			<u> </u>	Drill Holes	_	Off-set					
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	Wave/Twist in Tube				Fit/Function	1	JOut of S	Sequence				



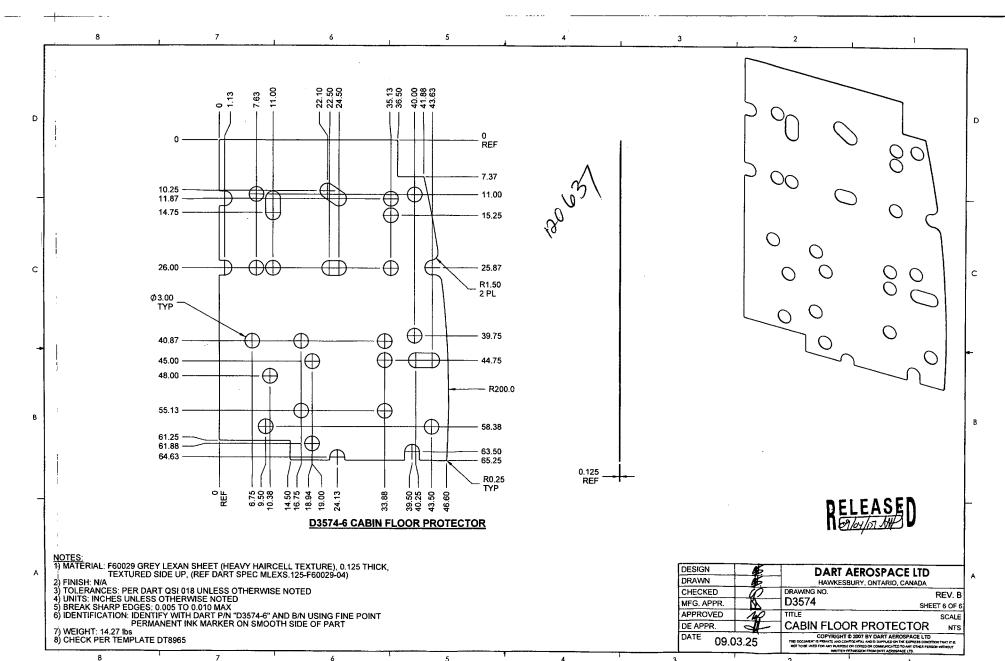
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QA Closed:			Date:			WORK ORDER NON	-CC	ONFOR	RMANCE / UPD/		ork Order up	date only	^A	EROSPACE
QA Closea.		*.	Date.			DISPOSITION				AGAINST DE			<u> </u>	
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Root					Desc	ription of work order update	[nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	n QCI	nspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	ing re													
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Landir	ing (Gear				General				, .	1			
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube					Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/Unquations Incomplete/Uncl gned/off center eled d	_	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Weld	ature/Cure Stock Pulled
	Heat Treat Inspection Strip in Tube Marks/Chatter					Cut Too Short Drawing Drill Holes		Mislabe Misrea Off-set Out of	eled d		Power Loss/	Surge	Other	—



DQA:	OQA: Date:													"A DT	
٠						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:					T		V	ork Order u	odate only			
Work Orde	er:					DISPOSITION			AGAINS	T D	DEPARTMENT/PROCESS				
	-					Rework			Skid-tube Crosstub	еГ	7	Water Jet		Engineering	
Part N	No.					Scrap			Machining Small Fa	-	- Pro	d. Eng. Coor.	Ħ	Quality	
	-					Use-as-is		Thermoforming Finishi			├─┤			Other	
NCR N	۱o		<u></u>			Suspected Unapproved		Large Fab Compos]	Supplier			
Root					Desci	ription of work order update		Initial	Action		Sign &		Т		
Cause		Date	Step	Qty		or non-conformance		nief Eng			Date	Verification	n	QC Inspector	
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	-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		L	Part Incorre		_	emperature/Cure	
	-		nk/Ripple,	/Wave		Burrs	<u> </u>	1	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	-	Veld	
	-	Cuffs				Contamination	L	4	ions Incomplete/Unclear	\vdash	Part Moved	l	\^	Vrong Stock Pulled	
	-	Crushing				Countersink	<u> </u>	1	ned/off center	\vdash	Positioned V		_		
	-	Heat Trea			<u> </u>	Cut Too Short	⊢	Mislabe		L	Power Loss/	Surge	C	ther	
	Inspection Strip in Tube		<u> </u>	Drawing	_	Misread	d								
	-	Marks/Ch				Drill Holes	<u> </u>	Off-set			 				
!		Turning S			-	Finish	Out of Calibration								
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence						



DQA:	Date:							TART							
						WORK ORDER NON-	-C(ONFO	RMANCE / UP						AEROSPACE
QA Closed:			Date:								Wo	rk Order up	odate only		
Work Ord	er:					DISPOSITION				AGAINST	ST DEPARTMENT/PROCESS				
	•					Rework			Skid-tube	Crosstube	Crosstube Water Jet				Engineering
Part I	No.					Scrap		Machining Small Fa			├			\dashv	Quality
	•	-				Use-as-is		Thermoforming Finishi							Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite			Supplier		
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Root					Desc	ription of work order update		Initial	Acti			Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	n	QC Inspector
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Doc/Data	Ш														
Equip/Tooling	Н														
Handling/Pre	\vdash				,						ı			1	
Material	Н										ł				
Operator Offset/Setup	Н										ļ				
Process	H										ı				
Supplier	Н										ŀ				
Training	H														
Transport															
Unapproved														- 1	
							FA	ULT CAT	regory						
Landi	ng G	Sear				General		_		_					
		Bending				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concen	ntric		BOM/Route	L	Grain				Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa			_	Part Incorred	ાં	_	Temperature/Cure
	Щ	Crimp/Kir	nk/Ripple,	/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Und	·		Part Lost/Mi	ssing	\dashv	Weld
	\vdash	Cuffs				Contamination	_	4	tions Incomplete/Ui	nclear	$\overline{}$	Part Moved	Į		Wrong Stock Pulled
	-	Crushing		<u> </u>	Countersink		-	gned/off center		$\overline{}$	Positioned W		_		
	Heat Treat		<u> </u>	Cut Too Short	⊢	Mislabe		<u> </u>		Power Loss/:	Surge [Other		
	Inspection Strip in Tube			Tube		Drawing	\vdash	Misread			-				-
	Marks/Chatter				<u> </u>	Drill Holes	\vdash	Off-set			-				
	-	Turning S		_	-	Finish	\vdash	₹	Calibration		-				
	Wave/Twist in Tube					Fit/Function	L	LOut of S	Sequence						



DQA:			_ Date:											
						WORK ORDER NON-	-C(ONFO	RMANCE / UPD	ATE				AEROSPACE
QA Closed:			Date:							W	ork Order u	odate only		
 Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT,			
	-					Rework		Skid-tube Crosstub			Water Jet			Engineering
Part N	lo					Scrap			<u> </u>	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thermoforming Finishi		Finishing	Rec/Sto	re/Packaging		Other
NCR No.			Suspected Unapproved			Large Fab Co	omposite		Supplier					
Root	Т				Desci	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	۱	QC Inspector
Design	\Box													
Doc/Data	_													,
Equip/Tooling	_													
Handling/Pre	_													
Material													- 1	
Operator	_	-											- 1	
Offset/Setup	_													
Process	4													
Supplier									1					
Training	-1											=	-	
Transport	_													
Unapproved			<u> </u>										1	
							FAI	ULT CA	TEGORY			1.5.1		
Landir [$\overline{}$	+				General]			January 1 . 100	Г	一.	D
	-	Bending	ot Concen		\vdash	Bend BOM/Route		1	Program	-	Outside Dim Over/Under		\neg	Pressure/Forced
•	\dashv	Centre No Cracks	or concer	itric	\vdash	Broken/Damage/Defect	\vdash	Grain			Part Incorred			Set-up
<u> </u>			nk/Ripple,	Mayo		Burrs		Hardwa	ire ion Incomplete/Unqua	lified	Part Lost/Mi	-		Temperature/Cure Weld
}	\neg	Cuffs	ik/ kippie/	vvave	-	Contamination		1	tions Incomplete/Uncle	⊢	Part Moved	2211 E		Wrong Stock Pulled
	-				\vdash	Countersink		4	gned/off center	-	Positioned V	/rong		wrong stock runed
	Crushing Heat Treat		·	Cut Too Short	-	Mislabe	•	-	Power Loss/		\neg	Other		
}	Inspection Strip in Tube			Tube	\vdash	Drawing		Misread		<u>t </u>	J. 04461 1033/	- L		-
<u> </u>	Marks/Chatter			, abc	-	Drill Holes	_	Off-set						
•					-	Finish		1	Calibration					
}	Turning Sequence Wave/Twist in Tube					Fit/Function		4	Sequence					

DART AEROSPACE LTD	Work Order:	120637
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept Rejec		Method of	Comments		
Dimension	10,0,4	Dimension			Inspection			
Ø3.00	+0.006/-0.001	3004			V	Jhm05		
7.37	+/-0.030	7.37	_		ν			
11.00	+/-0.030	11.00"	_		V	JAM08		
15.25	+/-0.030	15,95	_		T	Jkm07		
25.87	+/-0.030	25.87	-		7			
39.75	+/-0.030	39.75	_		7			
44.75	+/-0.030	44.75	_		т			
58.38	+/-0.030	58.38"	-		T	-		
63.50	+/-0.030	63.50"	-		T			
65.25	+/-0.030	65.25			T			
10.25	+/-0.030	10.25	_		ν			
11.87	+/-0.030	11.87	-		V			
14.75	+/-0.030	14.75	-		7			
26.00	+/-0.030	2 (c ·∞)°	-		T			
40.87	+/-0.030	40.87	_		て			
45.00	+/-0.030	45.00	_					
48.00	+/-0.030	48.00	-		Τ	<u>-</u>		
55.13	+/-0.030	55,13"	1		T			
61.25	+/-0.030	(e1.25	_		7			
61.88	+/-0.030	(e1/88°	-		T			
64.63	+/-0.030	64.63			T			
1.13	+/-0.030	1.13"			V			
7.63	+/-0.030	7.63			ν			
11.00	+/-0.030	11.00			V			
22.10	+/-0.030	22.10	-		丁			
22.50	+/-0.030	77.50	1		一丁			
24.50	+/-0.030	24.50	-		T			
35.13	+/-0.030	35,13	_		7			
36.50	+/-0.030	36.50			1			
40.00	+/-0.030	40.00	-		T T			
41.88	+/-0.030	41.88	~		T			
43.63	+/-0.030	43.65	_		T			
6.75	+/-0.030	6.75	-		γ			
9.50	+/-0.030	9.50	_		V	·		

QA: Date:					- ````````````````````````````````````									
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP	PDATE	W	ork Order up	odate only		AEROSPACE
					DISPOSITION			-	AGAINST		PARTMENT,	•		
Work Orde	er:				_						1			
Part No.				Scrap	· 1			Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR N	lo				Use-as-is Suspected Unapproved				re/Packaging Supplier		Other			
Root				Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause	se Date Step Qty		Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling				٠.										
Handling/Pre					-									
Material														
Operator								!					l	
Offset/Setup		ļ												
Process						Ì								
Supplier														
Training														
Transport														
Unapproved														:
						FA	ULT CA	ΓEGORY						
Landir	ng Gear				General		_				_	_		
	Bending				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ત્ર [Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave	L	Burrs		Inspect	ion Incomplete/Und	qualified		Part Lost/Mi	ssing		Weld
	Cuffs			L	Contamination		Instruct	tions Incomplete/Ur	nclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned V	/rong		
	Heat Treat			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other	
	Inspection	n Strip in	Tube		Drawing		Misread	d	'					
	Marks/Ch	natter			Drill Holes		Off-set							
	Turning S	equence			Finish	Out of Calibration								
ſ	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order: 4	201637
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38"	_		V	
14.50	+/-0.030	14.50°	-		T	
16.75	+/-0.030	16-75	-		7	
18.94	+/-0.030	1894	_		7	·
19.00	+/-0.030	19.00	_		T	
24.13	+/-0.030	24.13"	_			
33.88	+/-0.030	33.88	-		<u> </u>	
39.50	+/-0.030	39.50	_		T	
40.25	+/-0.030	40.25	-		T	
43.50	+/-0.030	43.50			T	
46.60	+/-0.030	46.60			T	
0.125	+/-0.010	0.125"			V	

	DAS	DAS		
Measured by:	22 9-89	Audited by: 27	Prototype Approval:	N/A
Date:		Date: 14-06-09	Date:	N/A

Rev	Date	Change	Revised by	Approved**
Α	08.01.16	New Issue	KJ//DD , A	
В	09.05.15	Dimensions updated per Dwg Rev B	KJ 95	

DQA:		Date:									•	DART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDAT		ork Order up	odate only	AEROSPACE
					DISPOSITION							
Work Ordei	r:				DIST 03/110/4	,				PARTMENT,		
					Rework		Skid-tube Crosstub				Water Jet	Engineering
Part No	o				Scrap		Machining Small Fal			Pro	Quality	
					Use-as-is		Thern	· · · · · · · · · · · · · · · · · · ·	nishing	Rec/Stor	re/Packaging	Other
NCR N	NCR No.				Suspected Unapproved		Large Fab Composite Supplie				Supplier	
Root			1	Desc	ription of work order update		Initial	Action		Sign &	,	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data	_											
Equip/Tooling										ļ		ļ
Handling/Pre											_	
Material	_					٠ ا					-	,
Operator		ĺ										
Offset/Setup	_											
Process												
Supplier												
Training												
Transport												
Unapproved		<u> </u>								<u>[</u>		<u> </u>
						FA	ULT CAT	regory				
Landin	_				General	_	1		_	1		.
-	Bending	_		-	Bend	<u> </u>	1	rogram	\vdash	Outside Dim	—	Pressure/Forced
-	Centre No	ot Concei	ntric	<u> </u>	BOM/Route	_	Grain		<u> </u>	Over/Under		Set-up
	Cracks		_	<u> </u>	Broken/Damage/Defect		Hardwa		. ⊢	Part Incorred		Temperature/Cure
	Crimp/Kir	ık/Ripple	:/Wave	<u> </u>	Burrs	<u> </u>	1	ion Incomplete/Unqualifie		Part Lost/Mi	ssing	Weld
-	Cuffs			-	Contamination	 	4	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing			-	Countersink	_	1 1	ned/off center	<u> </u>	Positioned W]
	Heat Treat			<u> </u>	Cut Too Short	-	Mislabe		Ĺ	Power Loss/:	Surge	Other
	Inspection Strip in Tube			\vdash	Drawing	—	Misread					
-	Marks/Ch			<u> </u>	Drill Holes		Off-set				•	
}	Turning So	•			Finish	<u> </u>	4	Calibration				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	Sequence				